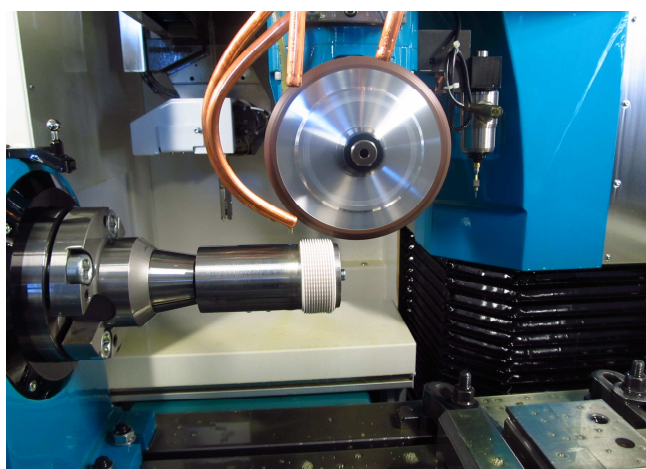
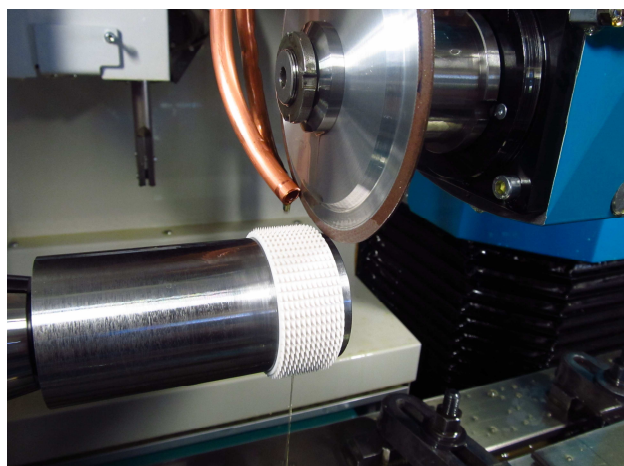
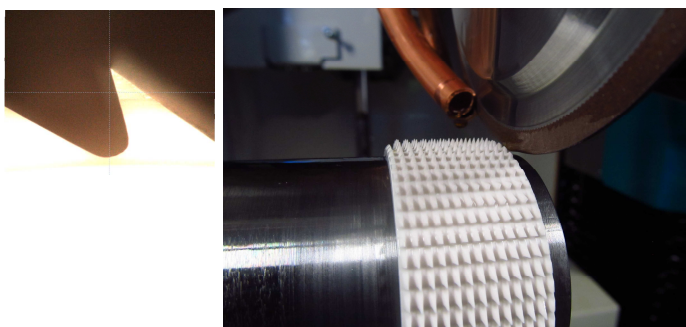



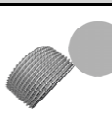

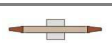
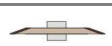
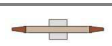
Ceramic Ring Ø64Z55P2

A30-200

The ceramic ring is ground in to process: a first process with form wheel to obtain the 2 mm thread. A second process generates the teeth when grinding the 55 flutes. The ceramic the ring are made of, is sensitive to temperature. Cooling with emulsion is necessary..



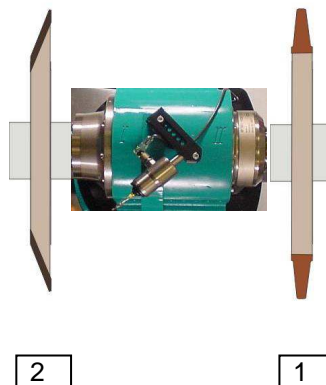
1. Cycletime for Production

| Workpiece: Ø 64 mm, Z 55, L 27 mm, Helix 2 mm Material CERAMIC | | | |
|--|---|---|---|
| Operations |  |  |  |
| Feed [mm/Min] | 180 | 170 | 1200 |
| Power [kW] | 1 | 2 | 1 |
| Cutting speed [m/s] | 12 | 12 | 12 |
| Used wheels |  |  |  |
| Grinding time [s] | 1805 | 972 | 211 |
| Total cycle time | 49 Min 48 | | |

The cycle times are indicative. Material to be ground, grinding wheels, coolants can influence the cycle times considerably.

2. Used Grinding Wheels

| | |
|---|-------------------|
| 1 | DXF Ø125-175 D126 |
| 2 | 1V1 Ø125-175 D126 |



3. Machine and Software Requirements

Machines: 5 axes CNC grinders : NORMA CFG

Control: Fanuc 31iA5

Accessories:

Responsible engineer: OP, 17.9.12

Coolant: Synthetic Emulsion, pressure 6 bar

Software: Quinto 5

www.schneeberger.ch

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